

March 10, 2010 1:31:18 PM

[illegible]

**Accept**

**Setup Start**

**Stop**

**Cust Item ID:**

**Abstract**

**Customer:**

**Approvals:**

### Process Plan:

Date: 10-3-10

**Tooling:****Date:**

Run Start

QC:

**Date:**

**SPC (Y/N):**

**Date:**

**Stop**

Draw Nbr	Revision Nbr
D2991	D

0.00

[illegible]

## Purchasing

## Purchasing

## Memo

0.00

## Purchasing

Issue P/O:

Description: D2991-2 side door

Supplier: Delastek

Ship to delastek: Qty 2 D2992-1 Doubler batch:  
Certificate of Conformity and process sheet from Delastek

277743

Ref 10-3-10  
C

0.00

[illegible]

Receive & Inspect for Damage & Mat'l Certs

### Packaging

## Memo

0.00

## Packaging

Ensure certificate of conformity is attached

Page 3 C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 56811

March 10, 2010 1:31:18 PM



Page 2

Item ID:	D2991-2	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Side Door					
Start Date:	10/03/2010	Start Qty:	1.00			
Required Date:	18/03/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC6- Inspect dimensions to drawing  Memo Ensure Material certification comply to Dwg D2991	0.00  0.00							
140  Packaging Packaging	Identify as per dwg & Stock Location:  Memo	0.00  0.00							
150  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

new work B is "ok" n

0.00

much up 380.

8/10/10

computer

0.00

0.00

25 10-05-10

10/05/10

mf

10-5-10.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

March 10, 2010 1:31:23 PM

Page 1

Work Order ID: 56811

Parent Item: D2991-2

Parent Item Name: Side Door

Comments: IPP rev. A 06.02.16 new issue (was done on D350-589-041) EC  
IPP Rev:B 08-02-20 ECN 1096 DD verified by:EC

Start Date: 10/03/2010

Required Date: 18/03/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2991-2P		Purchased	No			110	Each	1.0000	1.0000			
SIDE DOOR												

356811

85 10.05-10

## Warehouse

### Location

Main Warehouse

CA

53756

## Loc Qty

## Loc Code

1

1

D2992-1

Double

B47743 x2

C210/310 x2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# D2991-1/-2/-3 SIDE DOOR

## NOTES

- 1) LAYUP PER QSI 006 AND AS FOLLOWS
- 2) MATERIALS: RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
FOAM = 3/8", A500 CORE-CELL OR DIVINYLCELL OR AIREX OR KLEGECELL  
FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
- 3) FINISH INSIDE WITH DUPONT HIGHBUILD PRIMER GREY #1104S OR #1144S
- 4) USE MOLD DT8626 FOR D2991-1 SIDE DOOR  
USE MOLD DT8627 FOR D2991-2 SIDE DOOR  
USE MOLD DT8626 FOR D2991-3 SIDE DOOR (TRIM PER DT8631)
- 5) ROUTER FOAM CORE USING: DT8628 FOR D2991-1 SIDE DOOR  
DT8629 FOR D2991-2 SIDE DOOR  
DT8630 FOR D2991-3 SIDE DOOR
- 6) MAIN LAYUP: WHITE GLOSS GELCOAT #GEL 944W005  
9 OZ SATIN  
9 OZ SATIN  
FOAM  
FOAM STRIP  
9 OZ SATIN  
12 OZ UNIDIRECTIONAL (4.5" WIDE, 2 EDGES SHOWN)  
9 OZ SATIN  
RESIN (35-45% BY WEIGHT)  
PEEL PLY
- 7) BOND FOAM CORE USING POLYBOND B46F
- 8) DRILL Ø0.38 HOLE. REMOVE THE FOAM INNER LAYER 0.25 AROUND THE HOLE BETWEEN THE INNER AND OUTER SKINS. APPLY TAPE OR AN EQUIVALENT BACKER TO THE INNER SIDE OF THE HOLES TO PREVENT EPOXY FILLER FROM GOING THROUGH. FILL THE CAVITY BETWEEN THE SKINS COMPLETELY WITH HYSOL 934NA MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR HYSOL 956A/B MIXED WITH MILLED GLASS FIBERS TO A RATIO OF 10:1, OR METALSET A4, OR MAGNABOND 6398. ALLOW THE MATERIAL TO CURE. DRILL Ø0.191 THROUGH, 3 PLACES PER DOOR. SEE SECTION E-E.
- 9) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 10) UNITS: INCHES UNLESS OTHERWISE NOTED
- 11) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 12) IDENTIFICATION: NONE
- 13) WEIGHT: 9 lbs TYP

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 5681  
B-10-3-10

RELEASED  
2009-10-30  
*MD*

D	REFORMAT DWG, ADD DIMS TO DOUBLERS (ZN D7-2, D3-3, D7-4), X.X TOL WAS X.XX (ZN D7-2, D3-3, D7-4, A8-5, A4-5), D2992-1 NOW 4.000 WIDE (ZN D7-2, D5-3, D4-4), RMV DECAL (ZN A8-1), NCR 09-041	CP	09.09.26
C	UPDATE NOTES & MATERIALS; 1.25 WAS 0.50; ADD SECTION E-E; REMOVE D0589-041/-042/-043	MB	07.10.29
B	REMOVE D2621; 5.500 WAS 1.980	RF	02.02.22
A	NEW ISSUE	CP	02.01.23
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>CH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>CH</i>	DRAWING NO.	REV. D
CHECKED	<i>CH</i>	D2991	SHEET 1 OF 5
MFG. APPR.	<i>MD</i>	TITLE	SCALE
APPROVED	<i>MD</i>	SIDE DOOR	NTS
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DATE	09.09.26		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

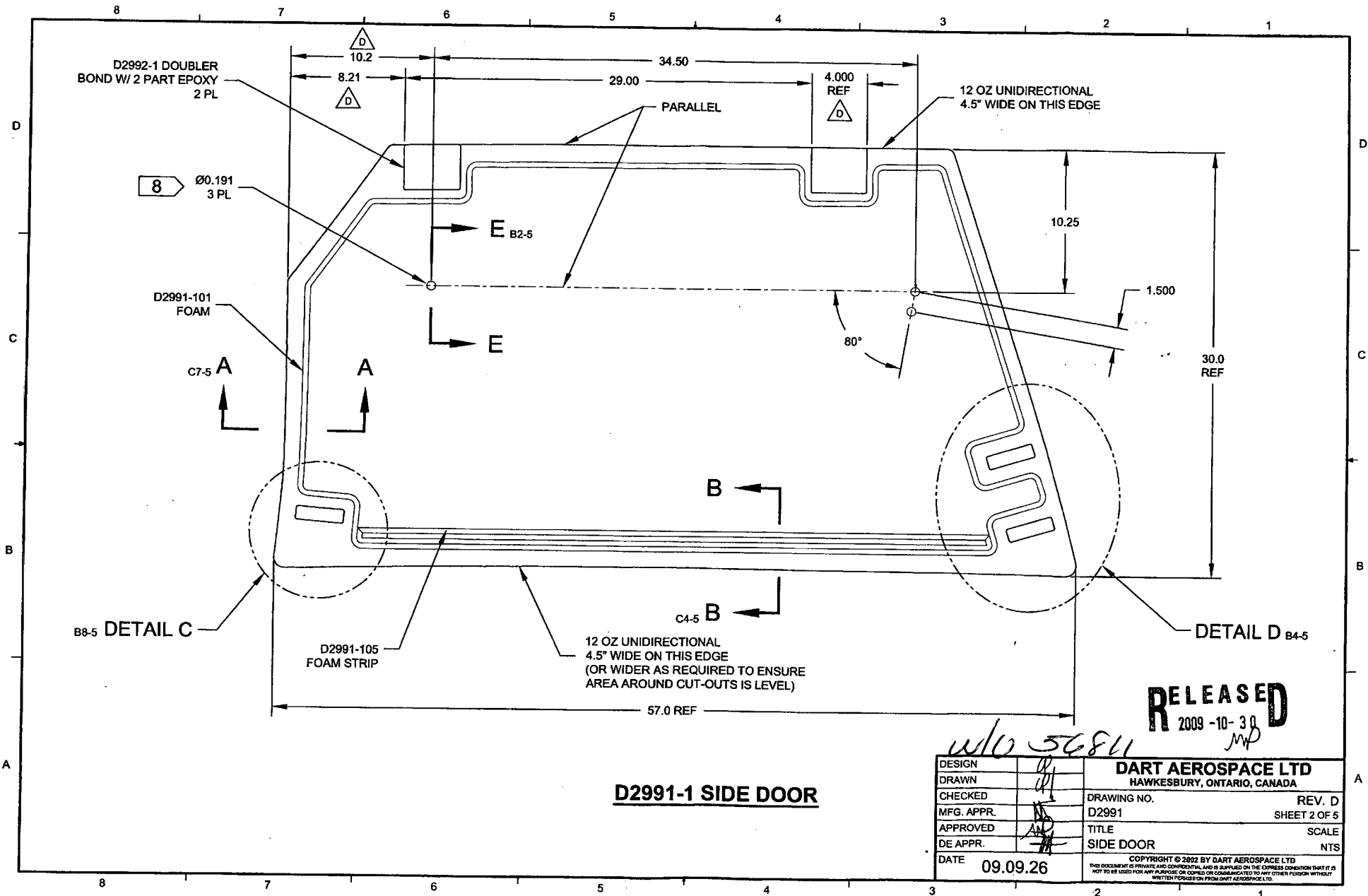
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





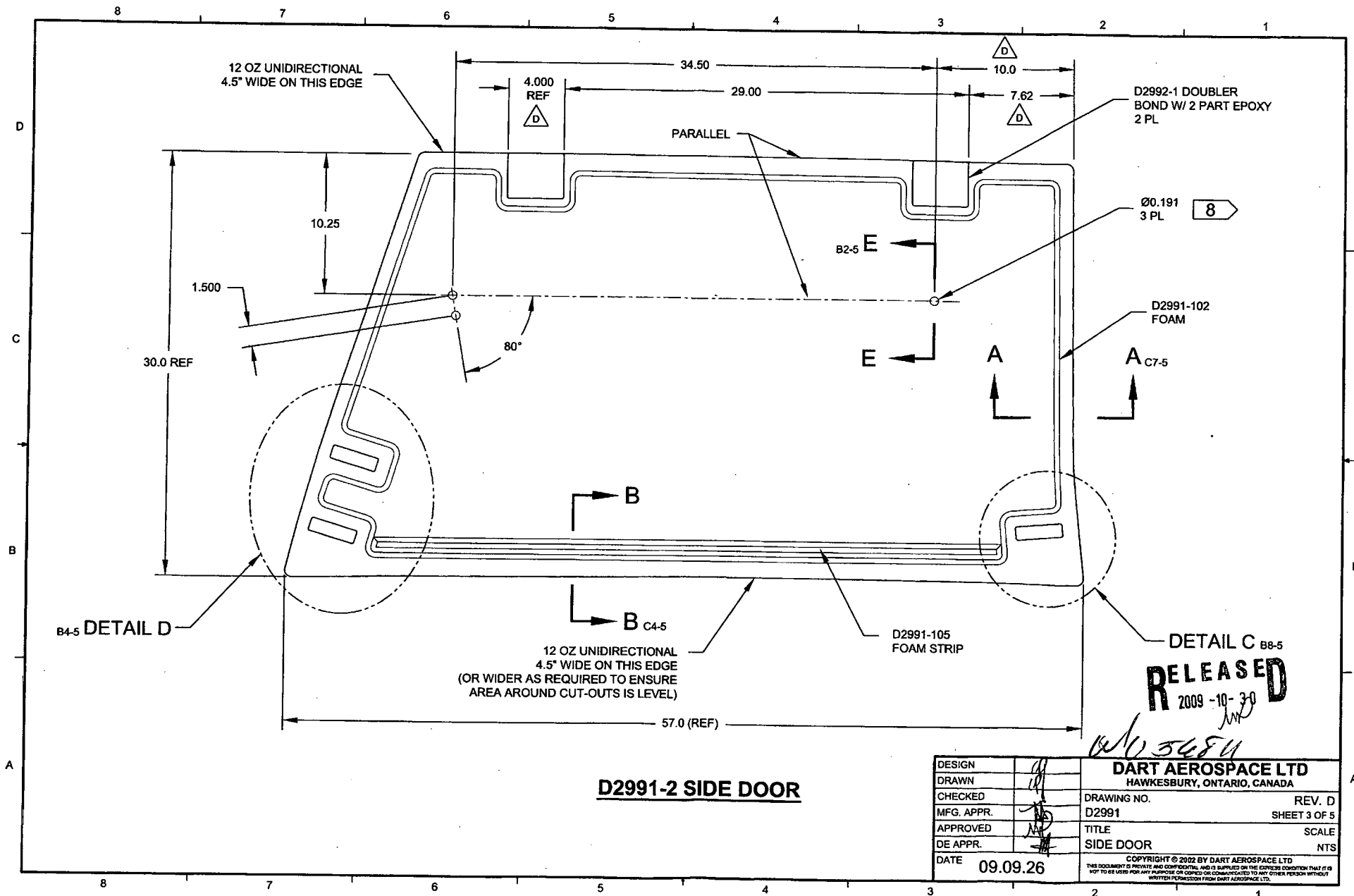
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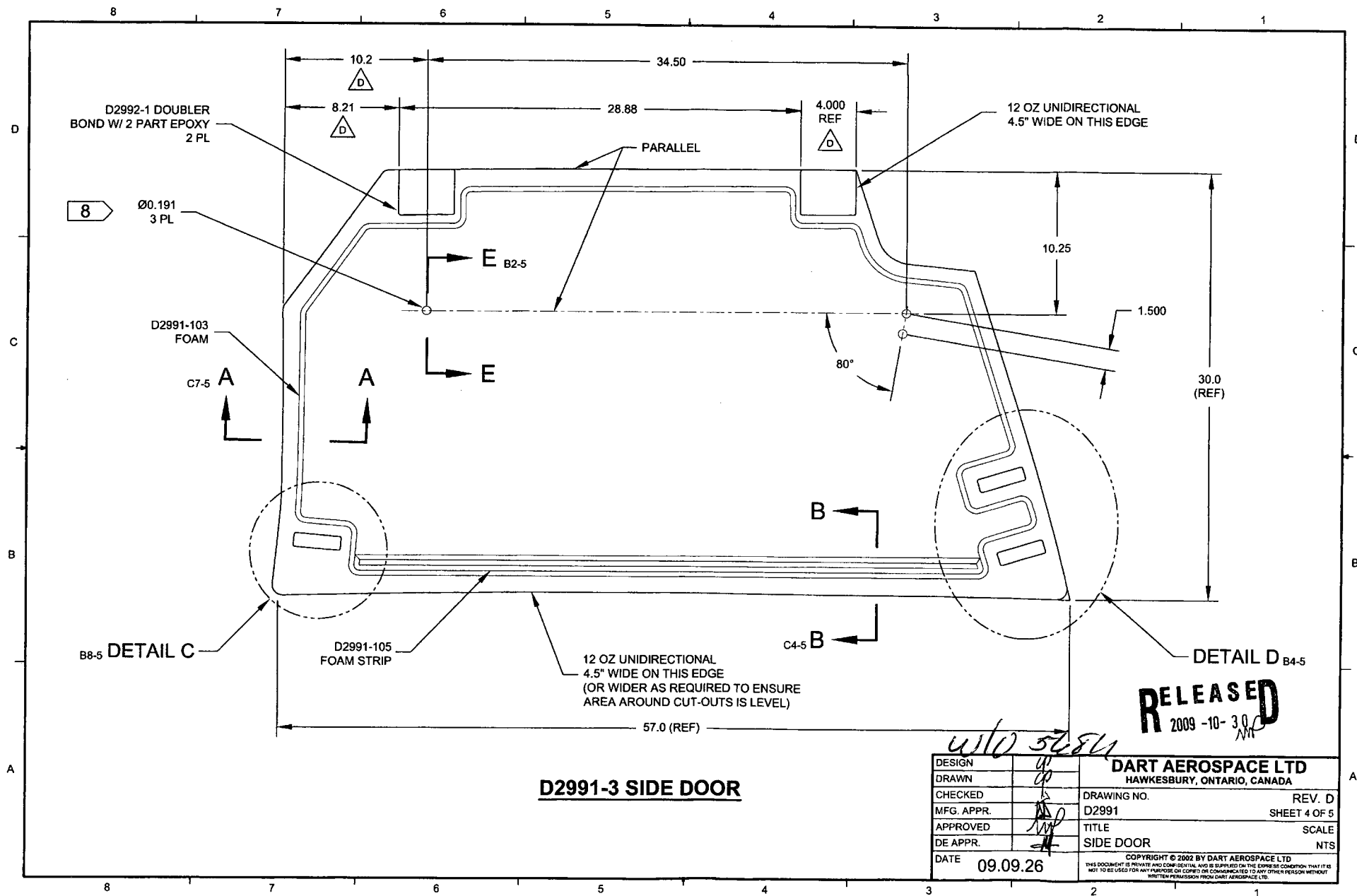
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**RELEASED**  
2009-10-30

DESIGN	W10 52861	<b>DART AEROSPACE LTD</b>	
DRAWN	W10 52861	HAWKESBURY, ONTARIO, CANADA	
CHECKED	W10 52861	DRAWING NO.	REV. D
MFG. APPR.	W10 52861	D2991	SHEET 4 OF 5
APPROVED	W10 52861	TITLE	SCALE
DE APPR.	W10 52861	SIDE DOOR	NTS
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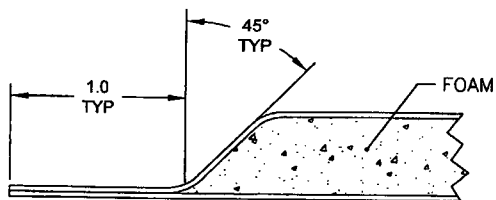
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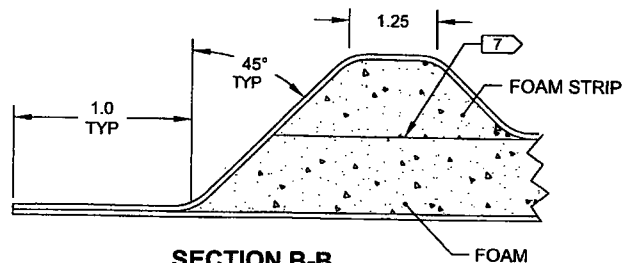
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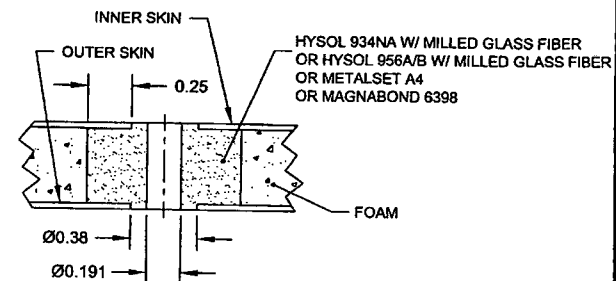
**NOTE:** Date & initial all entries



**SECTION A-A** C7-2, C2-3, C7-4  
NOT TO SCALE  
D2991-1/3 SHOWN  
D2991-2 OPPOSITE

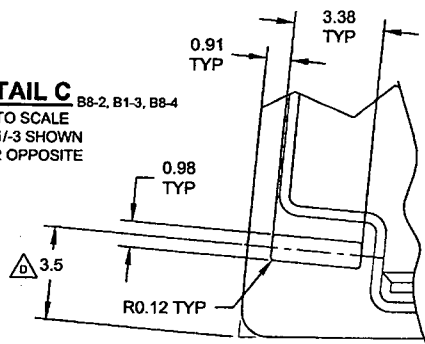


**SECTION B-B** B4-2, B5-3, B4-4  
ONE EDGE ONLY  
NOT TO SCALE, VIEW ROTATED  
D2991-1/3 SHOWN  
D2991-2 OPPOSITE

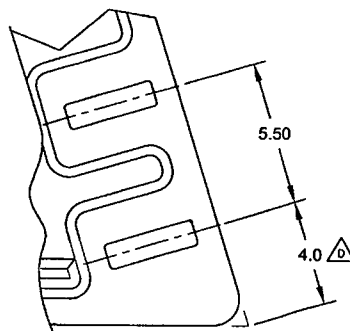


**SECTION E-E** D6-2, D3-3, C6-4  
TYPICAL Ø0.191  
HOLE DETAIL  
NOT TO SCALE

**DETAIL C** B8-2, B1-3, B8-4  
NOT TO SCALE  
D2991-1/3 SHOWN  
D2991-2 OPPOSITE



**DETAIL D** B1-2, B8-3, B1-4  
NOT TO SCALE  
D2991-1/3 SHOWN  
D2991-2 OPPOSITE



**RELEASED**  
2009-10-30

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2991	REV. D
MFG. APPR.		TITLE	SHEET 5 OF 5
APPROVED		DATE	SCALE
DE APPR.		09.09.26	NTS
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Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	32753
Customer #	DART US

Telephone: (819) 533-5788  
Warehouse: MAIN

**Bill to:**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-3336  
Contact: Linda Lacelle

**Ship to:**

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Ship via		F.O.B.		Terms		Salesperson	
Puro Collect		Origin		Net 30 days USA		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
29/04/2010	10/03/2010	13674	Brigitte Golden		PO114790		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
1	0	1	<u>DKC134-0067</u>	Line #3 Side Door N° D2991-2 B56811 U de M : Each Dwg.: D2991 Rév.: D			
				<div>No. Tot 24929</div> <div>Qté 1</div>			
				8/04/10			

8/04/10

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

*[Signature]*  
Quality department AQ-357



Date: Mardi, 2010-03-16 08:37:24  
 Utilisateur: marc dubé

## Feuille de Procédé

Client : DART US DART AEROSPACE LTD

Numéro Job : 24929

Numéro Soumission: 3761

Numéro B.A. :

Cette fois : 2010-03-16 No. B.V. :

Prsht Rev. : NC

Prem. fois : - - Type :

Job précédente : 24883

Écrit par :

Vérifié &amp; Approuvé par :

Commentaires : N. de pièce client: D2991-2

Nom Dessin : SIDE DOOR N. D2991-2

Numéro Article : DKC134-0067

Numéro Dessin : D2991

Projet Numéro : DK-134

Révision dessin : D

Matériel : Composites

Date Dûe : 2010-03-23

Qté: 1 Udm: UNITE

 Process Sheet Rév.: 00 Création du premier dans DKA à partir de la  
 Rév.: 00 De DKC

## Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description :

1.0 AAC0854 Frekote #700-NC

Commentair Qty.: 0.025 UNITE(s)/Unit Total : 0.050 UNITE(s)

1-26684-1

2.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.1667Hrs

Faire la préparation du moule N° DKO-0095 selon IG0019 (réf. IG 0009).

Date: 8-4-10 Sceau:



3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Commentair Qty.: 0.040 UNITE(s)/Unit Total : 0.080 UNITE(s)

1-26570-1

4.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0040 GALLON(s)/Unit Total : 0.0080 GALLON(s)

1-22176-1

5.0 AAC1606 UN2055 styrene monomere ST

Commentair Qty.: 0.010 GALLON(s)/Unit Total : 0.020 GALLON(s)

6.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.5000Hrs

Faire la préparation et l'application du Gel Coat selon IG0019, diluer à l'aide de 10% de UN2055 styrene monomere ST

Date: 8-4-10 Sceau: Temps Début: Temps Fin:



Date: Mardi, 2010-03-16 08:37:24  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 24929

Nom Dessin: SIDE DOOR N. D2991-2  
Numéro Article: DKC134-0067

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

7.0	AC0883	Tissu à délaminer Release ply B
-----	--------	---------------------------------

Commentair Qty.:	4.00 VERGE(s)/Unit	Total :	8.00 VERGE(s)
------------------	--------------------	---------	---------------

8.0	AC0884	Wrightlon 5200 Bleu P3
-----	--------	------------------------

Commentair Qty.:	6.00 VERGE(s)/Unit	Total :	12.00 VERGE(s)
------------------	--------------------	---------	----------------

9.0	AC0885	Feutre de drainage N° Airweave N 10
-----	--------	-------------------------------------

Commentair Qty.:	6.00 VERGE(s)/Unit	Total :	12.00 VERGE(s)
------------------	--------------------	---------	----------------

10.0	AC0943	Stretchlon 200 poche à vide Vert
------	--------	----------------------------------

Commentair Qty.:	18.00 PIED(s)/Unit	Total :	36.00 PIED(s)
------------------	--------------------	---------	---------------

11.0	AMB0214	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish
------	---------	---

Commentair Qty.:	7.3 VERGE(s)/Unit	Total :	14.6 VERGE(s)
------------------	-------------------	---------	---------------

1-26083-1

12.0	AMB0349	Fiberglass 12 oz Unidirectional
------	---------	---------------------------------

Commentair Qty.:	4.00 VERGE(s)/Unit	Total :	8.00 VERGE(s)
------------------	--------------------	---------	---------------

1-22549-1

13.0	AC0886	Ruban à gommer jaune #: T/AT-200Y
------	--------	-----------------------------------

Commentair Qty.:	2.0000 ROULEAU(s)/Unit	Total :	4.0000 ROULEAU(s)
------------------	------------------------	---------	-------------------

14.0	PREP-GENERAL	Préparation du matériel
------	--------------	-------------------------



Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.6667Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer ( non nécessaire lors du bagging du core ).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 19-3-10 Sceau:



15.0	AMB0212	Résine (411B7530) 411-350 promo. 75min.
------	---------	---

1-26805-2

Commentair Qty.:	0.400 KILOGRAMME(s)/Unit	Total :	0.800 KILOGRAMME(s)
------------------	--------------------------	---------	---------------------

16.0	AMB0286	Catalyst N° DDM-9
------	---------	-------------------

1-22176-1

Commentair Qty.:	0.0020 GALLON(s)/Unit	Total :	0.0040 GALLON(s)
------------------	-----------------------	---------	------------------

Date: Mardi, 2010-03-16 08:37:24  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 24929

Nom Dessin: SIDE DOOR N. D2991-2  
Numéro Article: DKC134-0067

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

17.0


PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.1667Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 9-4-10 Heure Début:      Heure Fin:      Sceau:  

18.0

LAMINAGE



Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.5000Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DKO-0095 et ensuite imbiber un pli de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 9-4-10 Heure Début:      Heure Fin:      Sceau:  

19.0

BAGGING



Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.5000Hrs

Installer la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Date: 9-4-10 Sceau:  

Curing début: 10:20 Curing Fin: 9:40

20.0

AAC1611

Polybond B46F

Commentair Qty.: 0.143 KIT(s)/Unit Total : 0.286 KIT(s)

1-2089-1

21.0

DKC134-0063

Foam Core N° D2991-102( Porte D2991-2)

Commentair Qty.: 1 UNITE(s)/Unit Total : 2 UNITE(s)

25119

22.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.5000Hrs

Retirez le bagging.

Installer le Foam Core D2991-102 selon IG 0033

Date: Mardi, 2010-03-16 08:37:24  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 24929

Nom Dessin: SIDE DOOR N. D2991-2  
Numéro Article: DKC134-0067



Numéro Job:



# Séq.:

Machine ou Opération:

Description:

Date: 13-4-10 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:  

23.0

BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.3333Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 2 heures minimum.

Date: 13-4-10 Sceau:  

Curing Début: 12:45 Curing Fin: 2:05

1-27127-1

24.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

1-26805-2

Commentair Qty.: 0.400 KILOGRAMME(s)/Unit Total : 0.800 KILOGRAMME(s)

25.0

AMB0286

Catalyst N° DDM-9

1-22176-1

Commentair Qty.: 0.0020 GALLON(s)/Unit Total : 0.0040 GALLON(s)

26.0



PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.1667Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 2% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 14-4-10 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:  

27.0

LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 1.0000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 14-4-10 Heure Début: \_\_\_\_\_ Heure Fin: \_\_\_\_\_ Sceau:  

Date: Mardi, 2010-03-16 08:37:24  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SIDE DOOR N. D2991-2

Numéro Job: 24929

Numéro Article: DKC134-0067

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

28.0

BAGGING


Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.3333Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Date: 14-4-10 Heure Début:        Heure Fin:        Sceau: 

Curing Début: 12:45 Curing Fin: 8:00

29.0


DÉMOULAGE

Démoulage



Commentair Setup: 0.00Hrs/ Run: 5.0000Hrs Total Run : 10.0000Hrs

Démouler la pièce en faisant bien attention de ne pas abimer les coins et les " edges ". Selon l'instruction générale de fabrication N° IG 0018

Date: 15-4-10 Sceau: 

30.0

TRIMAGE

Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 1.0000Hrs

À l'aide du gabarit N° DKO-0119 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de penture selon le dessin N° D2991.

Date: 15 avril 10 Sceau:   

31.0

~~AAC0205~~

~~COLLE HYSOL EA934NA~~

Commentair Qty.: 0.15 KIT(s)/Unit Total : 0.30 KIT(s)

32.0

AAC1540

Fibre de verre Miapoxy 66

Commentair Qty.: 0.0037 GALLON(s)/Unit Total : 0.0074 GALLON(s)

33.0

TRIMAGE

Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du Gabarit N° DKO-0119 Percer les 3 trous de 3/8" Dia.

À l'aide d'une clé Allen et en faisant bien attention de ne pas abimer les Skins de la pièce, venir faire un dégagement de 7/8" Dia dans le Foam Core entre les Skin intérieur et extérieur.

Date: Mardi, 2010-03-16 08:37:25  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 24929

Nom Dessin: SIDE DOOR N. D2991-2  
Numéro Article: DKC134-0067

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

À l'aide de masking Tape, masquer le trou de la skin extérieur.

À l'aide d'un mélange 10:1 de résine Hysol EA934NA / fibre courte Miapoxy 66 et d'une seringue, venir remplir les dégagements de 7/8" Dia préalablement fait dans le foam Core.

Laisser sécher.

Date: 16 avril 10 Sceau:



34.0

TRIMAGE

Trimage / Rivetage



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit N° DKC-0119 Repercer les 3 trous de 0.191" Dia.

Date: 19-4-10 Sceau:



35.0

AAC0205

COLLE HYSOL EA934NA

Araldite

1-26592-1

Commentair Qty.: 0.13 KIT(s)/Unit Total : 0.26 KIT(s)

36.0

AAC1681

N° D2991-2, Doubler

1-26921-1

Commentair Qty.: 2 UNITE(s)/Unit Total : 4 UNITE(s)

37.0

ASSEMBLAGE

Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide de l'adhésif N° Hysol EA934NA, assembler le doubler N° D2992-1 sur la pièce de composite selon le dessin.

Date: 19-4-10 Sceau:



38.0

AAC1021

Dupont Primer N° 7704S

Commentair Qty.: 0.1800 UNITE(s)/Unit Total : 0.3600 UNITE(s)

1-26006-1

39.0

AAC1101

N° 7775S, Dupont Activator - Reducer Chromabase

Commentair Qty.: 0.1800 UNITE(s)/Unit Total : 0.3600 UNITE(s)

1-26575-5

40.0

PRIMER

Application primer



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Préparer et appliquer le primer selon I.G. 0008 et la fiche technique.

Date: 23/04/10 Sceau:



# de Fiche Technique:

N/A

Date: Mardi, 2010-03-16 08:37:25  
Utilisateur: marc dubé

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 24929

Nom Dessin: SIDE DOOR N. D2991-2  
Numéro Article: DKC134-0067

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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41.0	INSPEC FINAL	Inspection finale
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Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.5000Hrs

Faire l'inspection selon le dessin N° D2991



Date: 28-40 Heure Début: — Heure Fin: — Sceau: —

42.0	EMBALLAGE	Emballage & Entreposage
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Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.1667Hrs

Faire l'emballage des pièces.

Quantité: 1 Date: 28-04-10 Sceau: —

